

Work Order ID 67841

Thursday, March 31, 2011 3:47:22 PM



Page 1

Item ID: D3017-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Frame Assembly

Start Date: 4/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-03-31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3017	Rev B

100 Weld per dwg A/R 4130 rod Batch: M100075 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017

2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)

3-Drill holes in D3017-5 Using DT8622

4-Deburr

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

6-Drill holes in back frame using DT8621

EL 11-4-21

X1

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

1 Q BE 11/04/21

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

8/6/21



QC

Memo

0.00

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 12:30
OVEN TEMPERATURE: 400°
FINISH TIME: 1:00

11 04 21 ①

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

E/S 4/04/25 ①

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: G-A 0.00

Packaging

Memo

w/o 67840

0.00

Packaging

E 5/4/25 @

160

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/4/25 J

R 11-04-25
①

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NOTE: Date & initial all entries

Picklist Print

Thursday, March 31, 2011 3:47:29 PM

Page 1

Work Order ID: 67841

Parent Item: D3017-041

Parent Item Name: Back Frame Assembly





Start Date: 4/1/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19 New issue EC
IPP RevB: as per revB/ DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.083  4130 RD Tube .750 x.083W		Purchased	No			100	f	6.5800	2.458	2.587368			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT033				6.58					
				13812				6.58		2.5			
M4130NT0.750W.049  4130 RD Tube .750 x.049W		Purchased	No			100	f	85.2300	11.125	11.71053			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT033				85.23					
				10133				10.73					
				110740				74.5		9.6			
D3017-11  cap		Manufactured	No			100	Each	12.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA019				12					
				52583				12		2			
D3017-7  Lug		Manufactured	No			100	Each	13.0000	3	3			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA019				13					
				38567				2					
				52915				11		3			

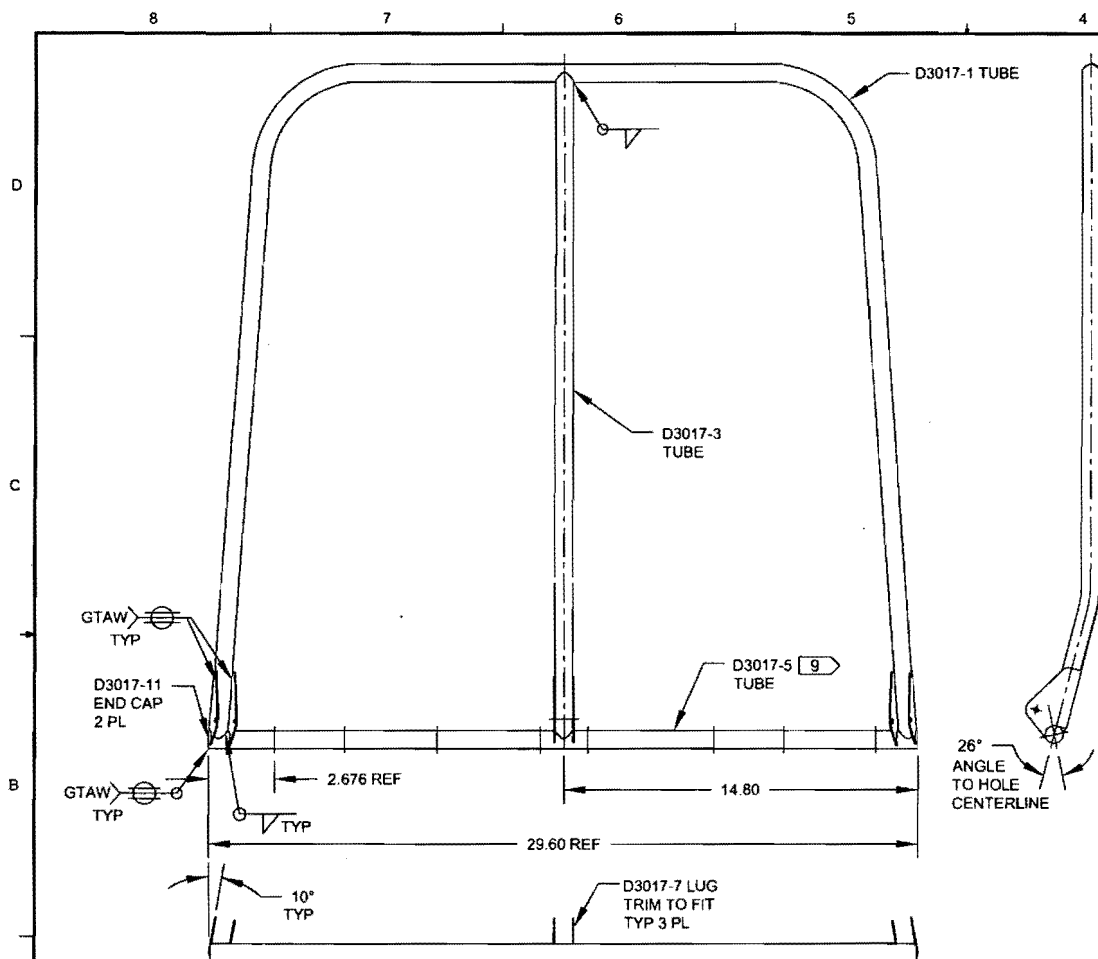
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D3017-041 BACK FRAME ASSEMBLY

ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

DRILL Ø0.128 HOLES TO LINE UP WITH D3023-1 BACK PANEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67841

RELEASED
2010-02-02
WJP

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 4.50 lbs
 - 8) WELD PER DART QSI 004
 - 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

B	REFORMAT DWG, .5 TUBE WALL THICKNESS REV'D (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D3017 SHEET 1 OF 4
TITLE SCALE
BACK FRAME ASSEMBLY NTS

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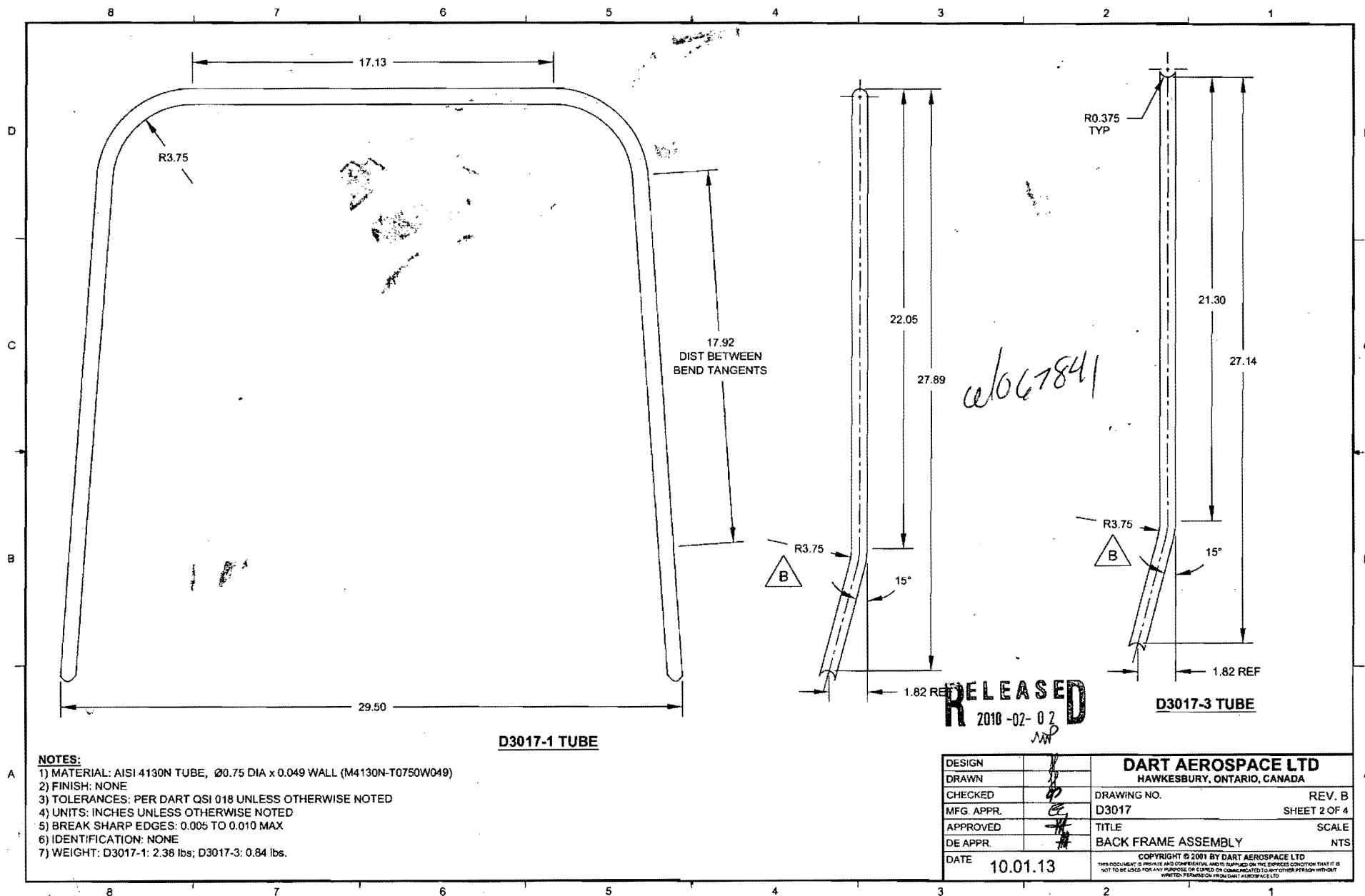
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NOTE: Date & initial all entries



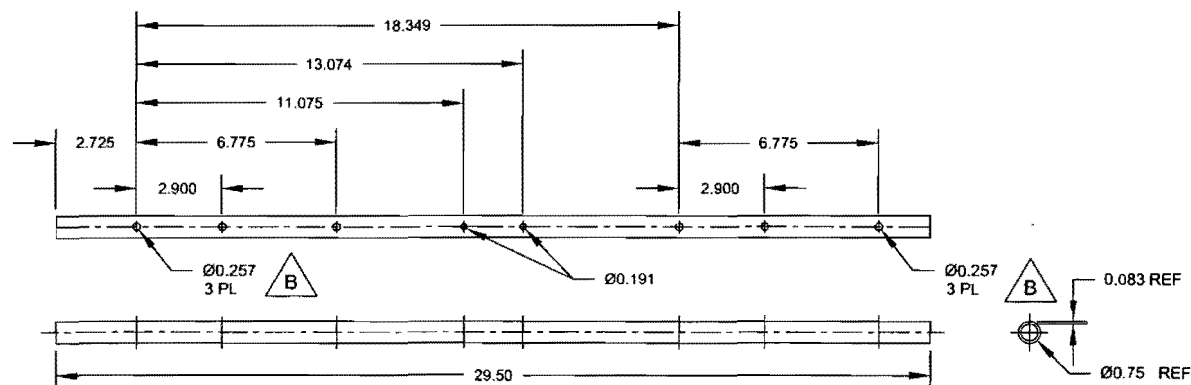
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D3017-5 TUBE

W/O 67841

RELEASED
2010-02-02

- NOTES:**
- 1) MATERIAL: AISI 4130N TUBE, $\varnothing 0.75$ DIA x 0.083 WALL (M4130N-T0750W083)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.89 lbs



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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BACK FRAME ASSEMBLY	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

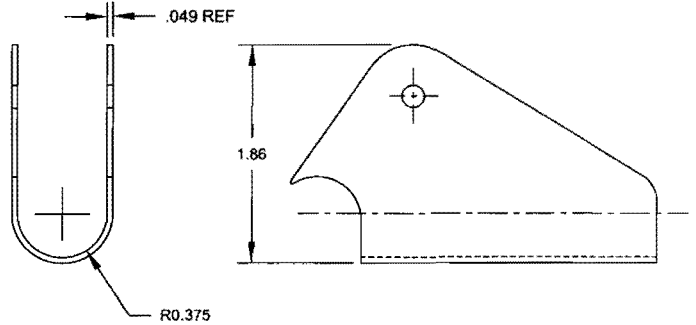
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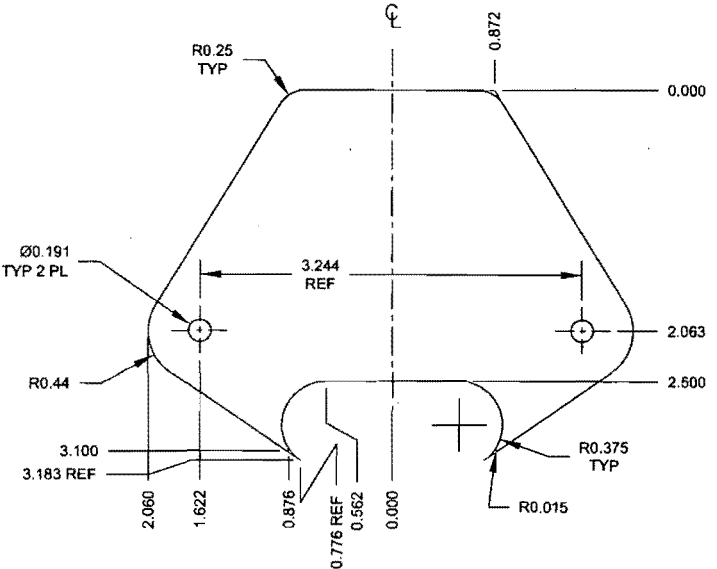
8 7 6 5 4 3 2 1

D



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F

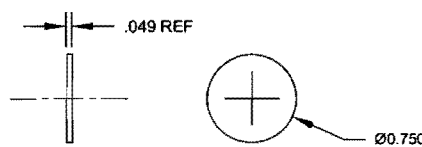
C



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

D

B



D3017-11 END CAP

B






A

- NOTES:**
- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

8 7 6 5 4 3 2 1

w/6 67841

RELEASED
2010-02-02
MP

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A

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